

Work Order ID 60579

July 14, 2010 2:48:11 PM



Page 1

Item ID: D350-607-045A

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/14/10 Start Qty: 1.00



Required Date: 7/16/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

U

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Cust Item ID:

Customer:

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-607-045	CHG	CHG003		
DESC	Heli-Utility-Basket	STC	SH94-14		
LOT	B51180	STC	SR00213NY		
MODEL	AS350/355	STC			
MADE IN CANADA				D2729-1	

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DC

DOCUMENT CONTROL

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPPD350-607-045A CHG001

SB 10/07/20

110

Pick Kit

0.00



Packaging

Memo

0.00

PULL FROM STOCK

1 X D350-607-045 B *51180*

SB 10/07/15

120

Small Fab

0.00



Small Fab

Memo

0.00

REMOVE PROP ARM

D2332-041 B _____, RETURN TO STOCK

SB 10/07/15

10-7-20

②

①

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Page 2

Item ID: D350-607-045A

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Start Date: 7/14/10 Start Qty: 1.00

Required Date: 7/16/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

122



Large Fab

Large Fab

Memo

GRIND FLUSH D2327-3 BUSHING.
TRIM STEEL MESH LOCALLY A/R
TRANSFER DRILL 2 X 0.194 HOLES THRU BASKET LID SQUARE TUBE
AND 2 X 0.194 HOLES THRU BASKET BASE SQUARE TUBE PER DETAIL
M

0.00

0.00

123



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

124



Small Fab

Small Fab

Memo

RE-Assemble as per Dwg D350-607
TO MAKE D350-607-045A
PER ICA PG 8

0.00

0.00

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Pl 10-07-16

S 10/07/16

(80)

Sb 10/07/20

(1)

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Item ID: D350-607-045A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

Pick Kit

0.00



Packaging

Ensure original kit in box
Memo

0.00

Packaging

u

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/10

(+)

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

RE-Identify and pack for shipping as per PPPD350-607-045A, USING NEW
B/N
NEW LABELS REQ'D
Location: _____

8/17/10

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Item ID: D350-607-045A

Accept

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/14/10 Start Qty: 1.00

Required Date: 7/16/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Proof 20
MF
10-7-20

Picklist Print

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Page 1

Work Order ID: 60579



Parent Item: D350-607-045A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/14/10

Required Date: 7/16/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
as per ecn 10-545 DD 10.04.19 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-607-045 Manufactured No



Heli-Utility-Basket, LH/RH

Each 2.0000

1



Location

Loc Qty

Loc Code

FG101

2

51180

1

55590

11

D350-607-145 Manufactured No



Automatic Lid Opener Installation

110

Each

2.0000

1

1



Location

Loc Qty

Loc Code

FG032

2

52755

2

SP 10/02/20

SP 10/07/20

- 4.2.6 Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.3 D350-607-145 AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)

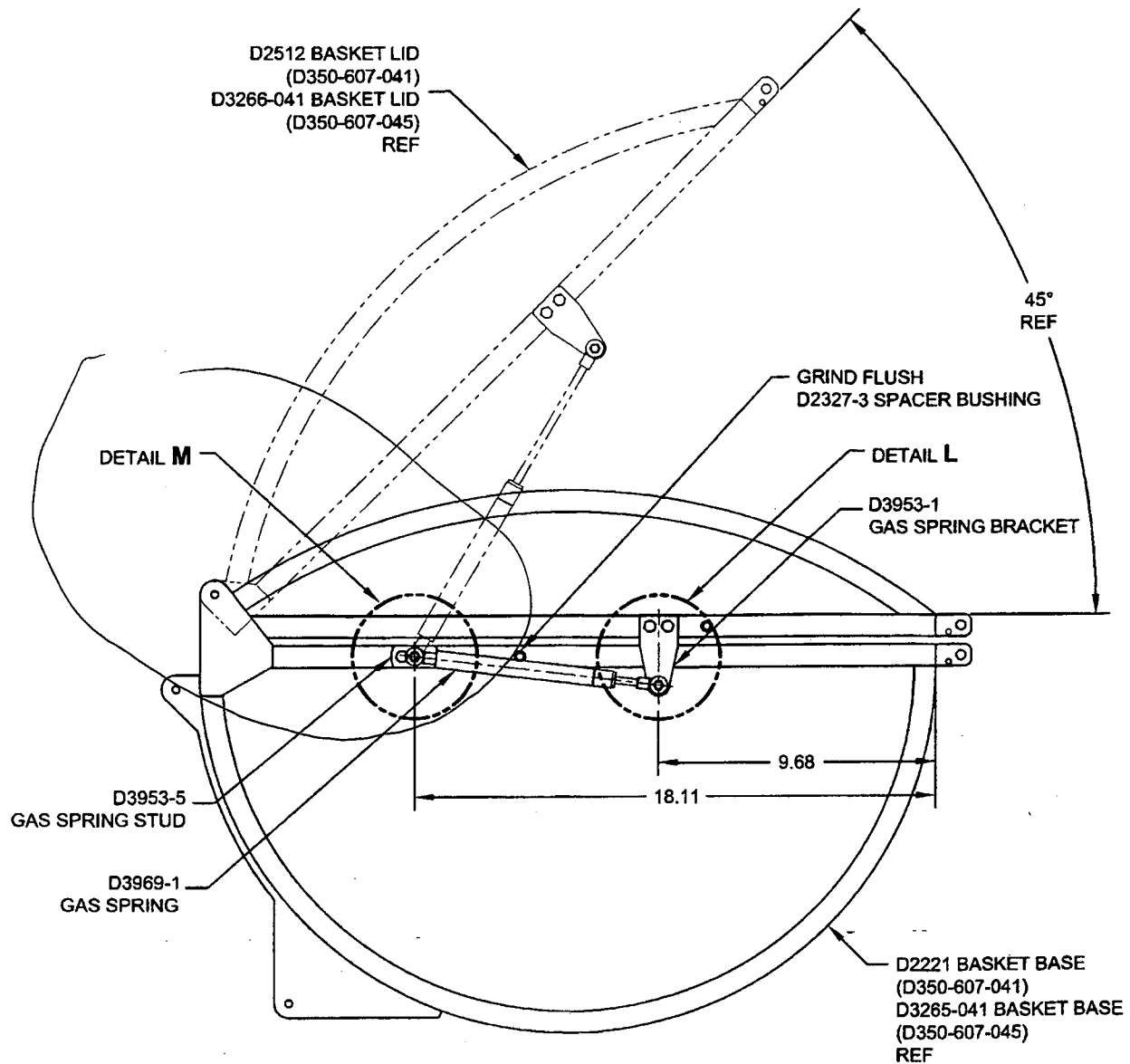
NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.3.1 Remove the D2332-041 Prop Arm.
- 4.3.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 8a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.3.3 Locate the D3953-1 Gas Spring Bracket as shown in Figure 8a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket lid square tube structure as shown in Detail M. Install the D3953-1 Gas Spring Bracket & D3953-13 Gas Spring Spacer using 2X AN3C16A Bolt, 2X NAS1149C0332R washer & 2X MS21043-3 Nut as shown in View P-P.
- 4.3.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.3.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.3.6 Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16" open end spanner/wrench.
- NOTE:** With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.3.7. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.4 D350-607-241 BASKET CLAMP KIT INSTALLATION

Refer to Section 3.0 of these instructions to install the D350-607-241 Basket Clamp Kit. Amend weight and balance accordingly per Section 5.0 of these instructions for each D350-607-241 Kit installed on the aircraft.

60579



D350-607-141 AUTOMATIC LID OPENER INSTALLATION
(BOTH ENDS)

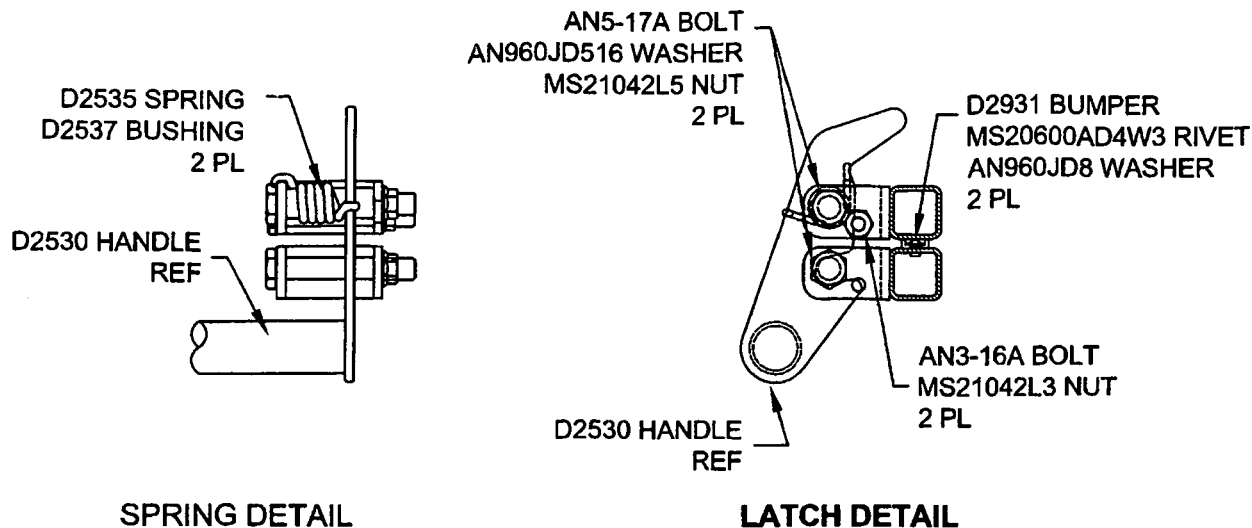
D350-607-145 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

FIGURE 25-7A - AUTOMATIC LID OPENER INSTALLATION

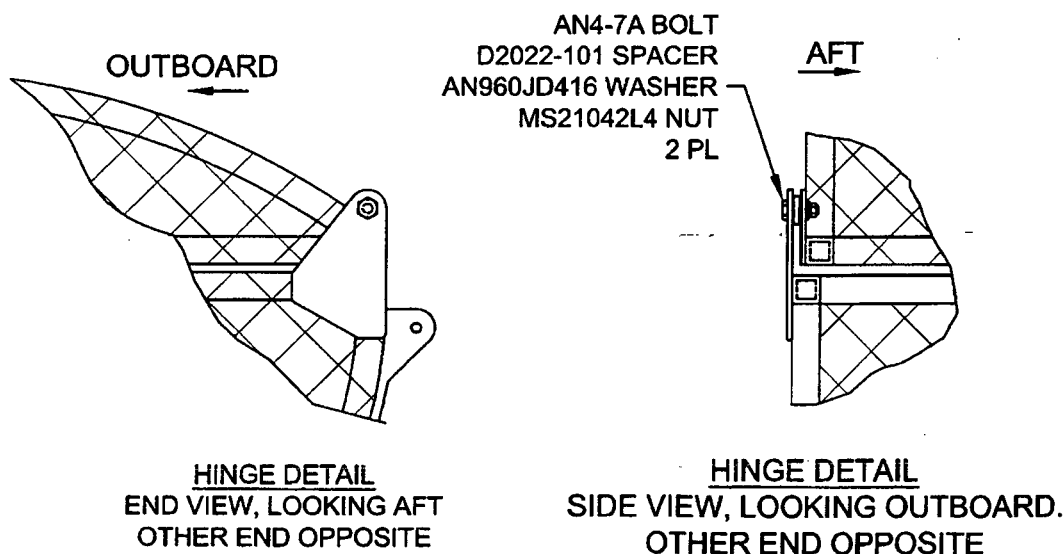
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25-00-00



**DETAIL J:
HANDLE WELDMENT**



**DETAIL H:
HINGE**

**FIGURE 25-6 - D350-607-041/-041A/-043/-043A/-045/-045A/-047/-047A HELI-UTILITY BASKET™
HINGE AND HANDLE DETAILS**

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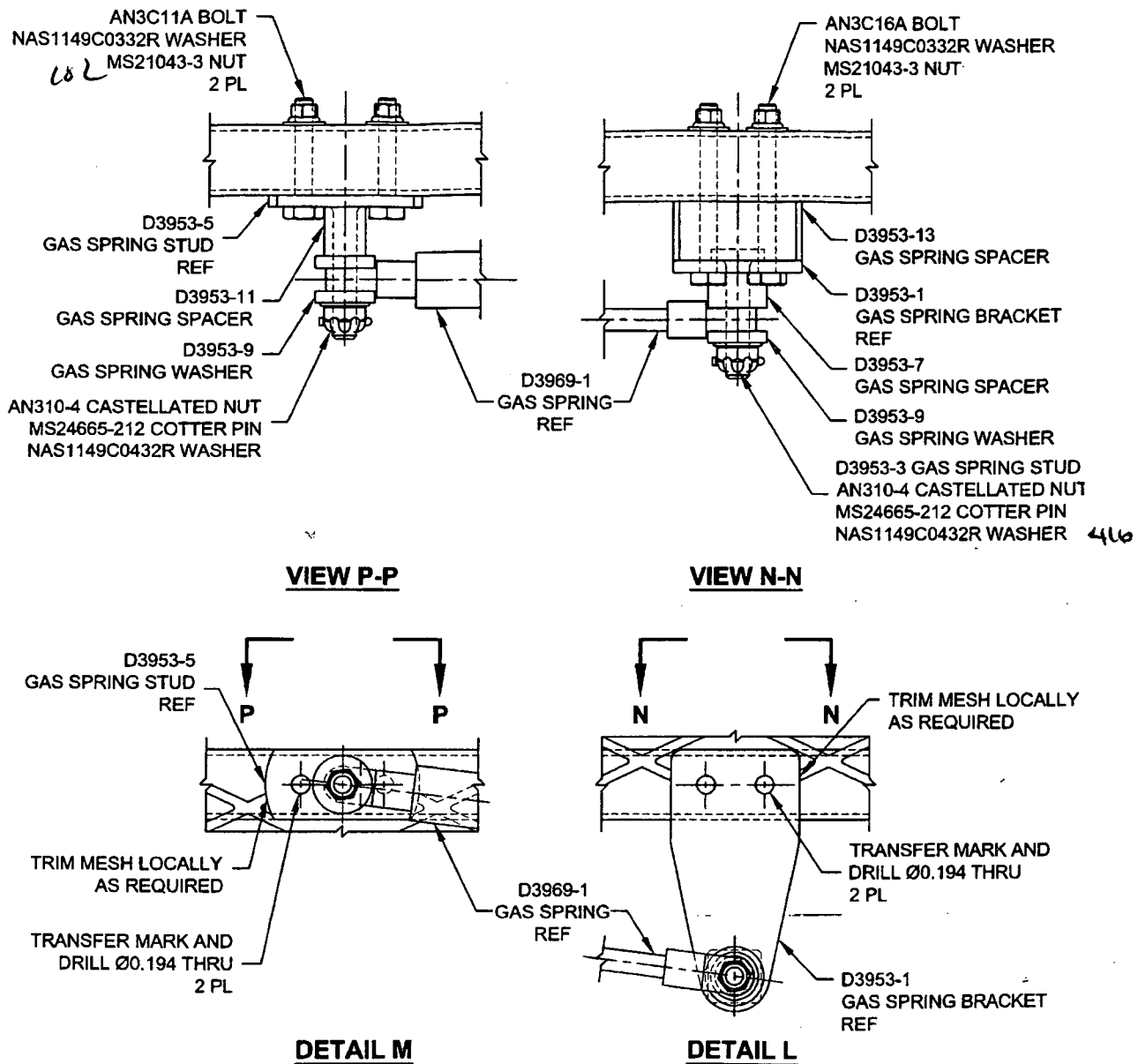


FIGURE 25-7B - AUTOMATIC LID OPENER INSTALLATION DETAILS

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